

Work Order ID 55102

January 6, 2010 9:46:44 AM

Page 1

Item ID: D3589-047

Accept



Setup

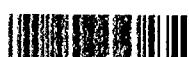
Start



Revision ID:

Item Name: FWD GUIDE

Stop



Start Date: 06/01/2010 Start Qty: 2.00

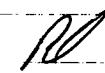


Required Date: 15/01/2010 Req'd Qty: 2.00



Reference:

Approvals: Process Plan:



Date: 10-1-06

Tooling:

Date:

Run

Start



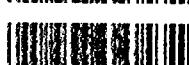
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3589	Rev B

100 Weld per dwg A/R S.S. rod Batch: M109213 0.00



Large Fab

Memo 0.00

Large Fab

1- assemble and weld as per dwg D3589 QSI004

A/R Stainless Steel rod batch: M109213

DD 10.01.13

(2)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo 0.00

Quality Control

GJC 10/01/13

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo 0.00

Quality Control

→Σ 10.01.13

(x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55102

January 6, 2010 9:46:44 AM

Page 2

Item ID: D3589-047

Accept



Setup Start



Revision ID:

Item Name: FWD GUIDE

Stop



Start Date: 06/01/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 06/01/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
**Draw
Number**
**Draw
Rev.**
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

130



Identify as per dwg & Stock Location:

72

0.00

10-1-18 SL (2*) 5

Packaging

Memo

0.00

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

10/01/19 AF

QC

Memo

0.00

Quality Control

MF 10-1-18

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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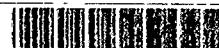
NOTE: Date & initial all entries

Picklist Print

January 6, 2010 9:46:48 AM

Page 1

Work Order ID: 55102



Parent Item: D3589-047



Parent Item Name: FWD GUIDE

Start Date: 06/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
----------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3589-17		Manufactured		No		100	Each	5.0000	2.0000			
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FWD GUIDE PLATE

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	5	
45011	5	

PD 10.01.13

D3589-5		Manufactured		No		100	Each	4.0000	2.0000			
---------	--	--------------	--	----	--	-----	------	--------	--------	--	--	--



LATCH GUIDE

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	4	
46104	4	

PD 10.01.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

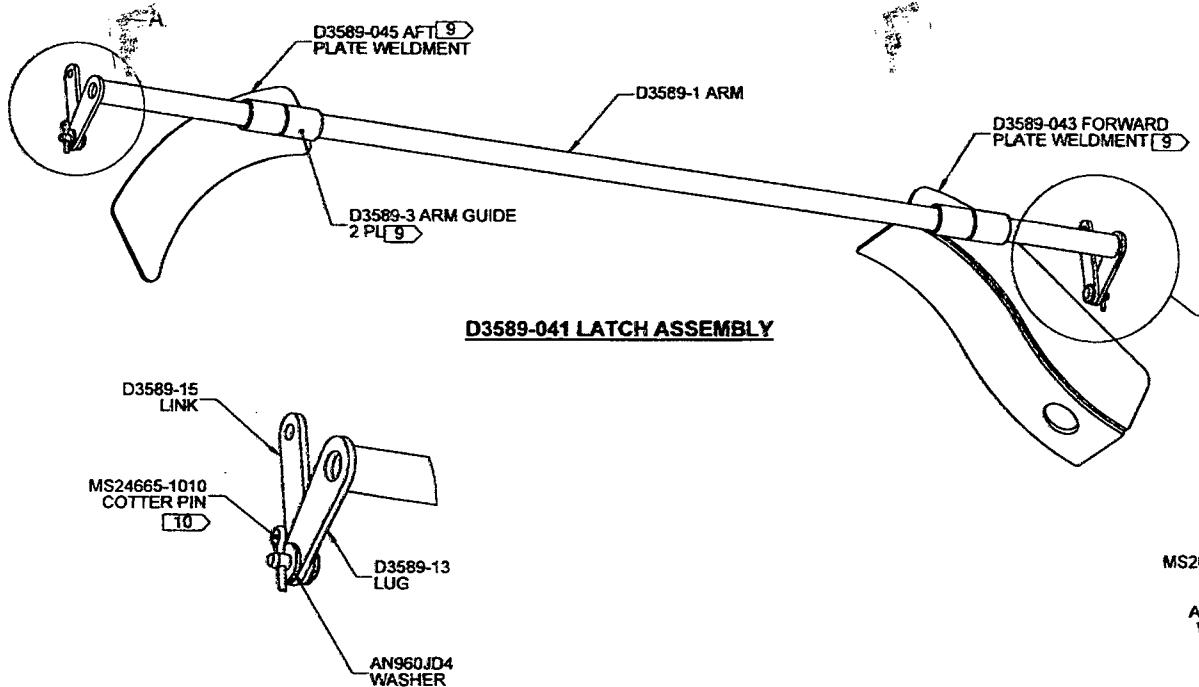
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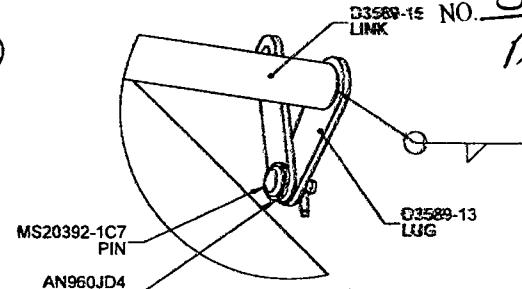
8 7 6 5 4 3 2 1

QTY -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

50102
B10-1-04



DETAIL B: WELDING AND
LINK ASSEMBLY DETAIL
SCALE 2X
2 PL

RELEASED
08/05/04

DETAIL A: LINK ASSEMBLY DETAIL

SCALE 2X
2 PL

D3589-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
- 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

B	0.50 AND 0.63 REF WIRE 1.97 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C5-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 29° WAS 15° (ZN B7-2); 13.06 WAS 18.88 (ZN D4-4); REDESIGNED D3589-9 (ZN A8-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	WB	08.06.25
A	NEW ISSUE	NC	08.05.29
REV.	DESCRIPTION		
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DRAWING NO. D3589		
CHECKED	REV. B SHEET 1 OF 8		
MFG. APPR.	APPROVED		
APPROVED	TITLE LATCH ASSEMBLY		
DE APPR.	SCALE NTS		
DATE 08.06.25	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS PROVIDED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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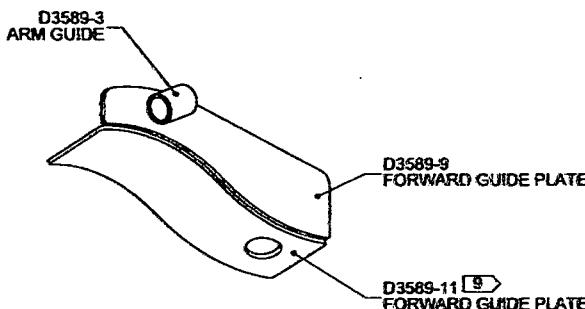
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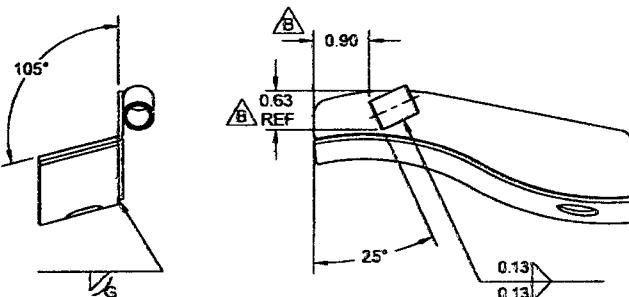
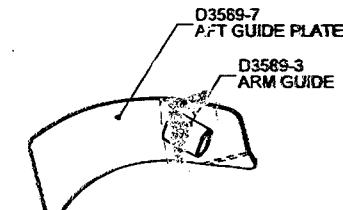
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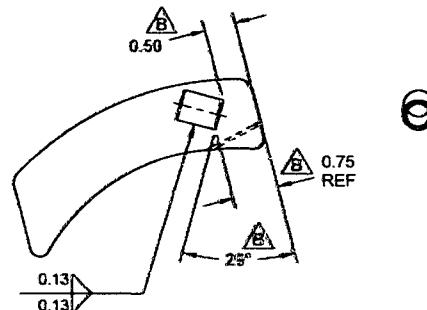
D



QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
1	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE



D3589-043 FORWARD PLATE WELDMENT



D3589-045 AFT PLATE WELDMENT

D3589-043/045 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D3589-043 = 0.22 lbs
 - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

DESIGN	<i>1</i>	DART AEROSPACE LTD	
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>1</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>1</i>	D3589	SHEET 2 OF 8
APPROVED	<i>1</i>	TITLE	
DE APPR.	<i>1</i>	SCALE	
DATE	08.06.25	LATCH ASSEMBLY	
NTS			
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W/0 55102
RELEASED
07/03/06 MA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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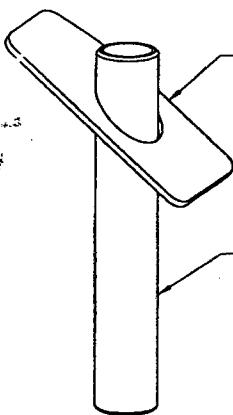
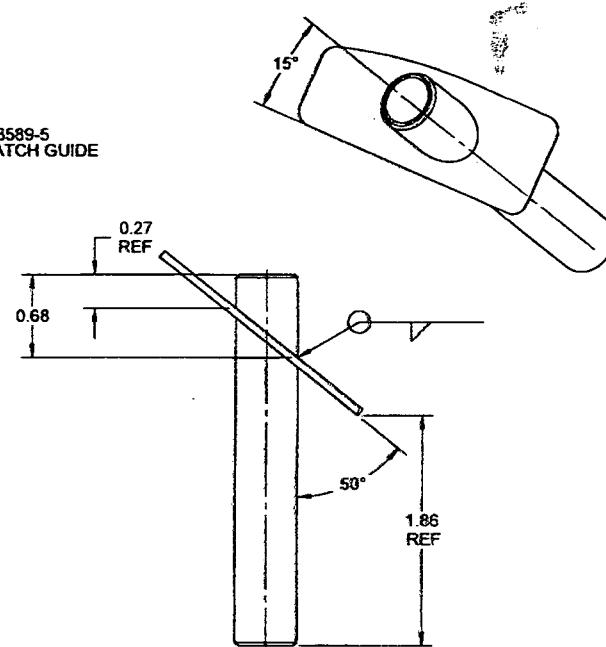
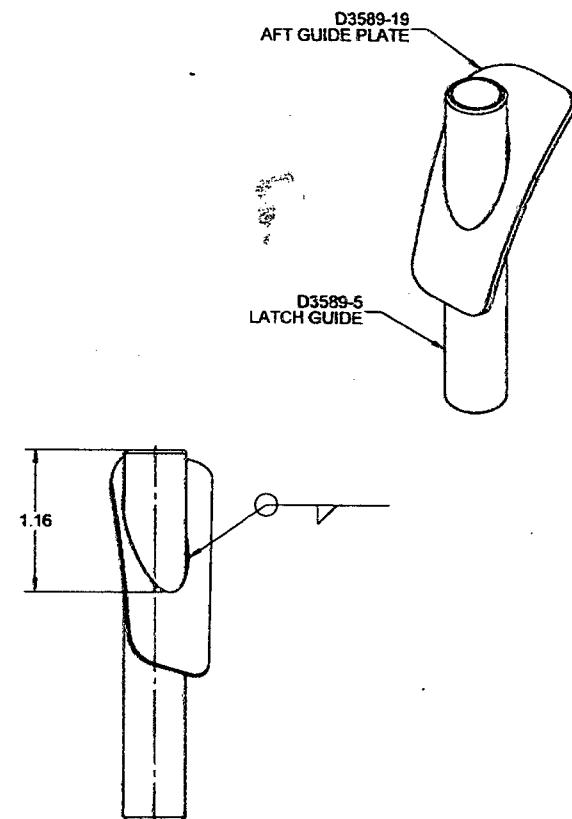
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D3589-17
FORWARD GUIDE PLATED3589-047 FORWARD GUIDED3589-049 AFT GUIDE

RELEASED
07/26/11

D3589-047/049 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs EACH
- 8) WELDING: PER DART QSI 004

DESIGN	<i>1</i>
DRAWN	<i>1</i>
CHECKED	<i>PH</i>
MFG. APPR.	<i>1</i>
APPROVED	<i>1</i>
DE APPR.	<i>1</i>
DATE	08.06.25

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3589 REV. B
SHEET 3 OF 8

TITLE: LATCH ASSEMBLY SCALE: NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

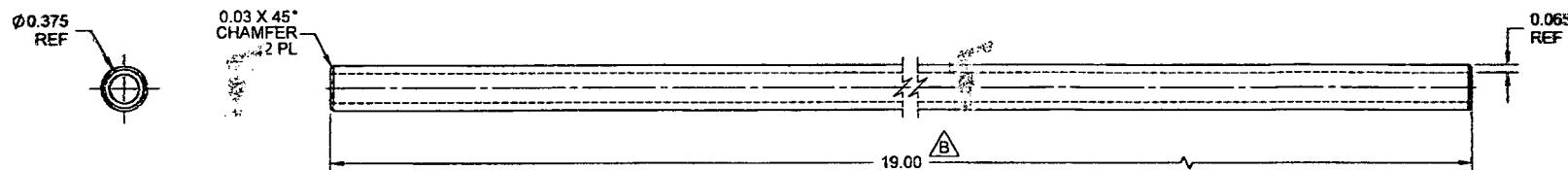
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

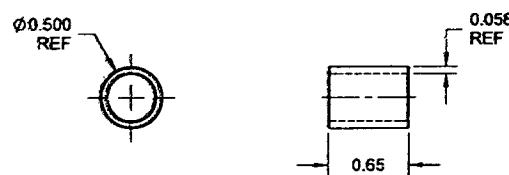
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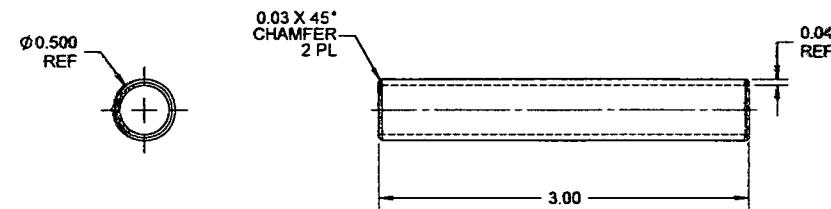
8 7 6 5 4 3 2 1



D3589-1 ARM



D3589-3 ARM GUIDE



D3589-5 LATCH GUIDE

D3589-1/-3/-5 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
- D3589-3 = 0.01 lbs
- D3589-5 = 0.06 lbs

RELEASED 01/01/05 NTS

W/0 55102

DESIGN	<i>1</i>	DART AEROSPACE LTD
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO. D3589
MFG. APPR.	<i>PH</i>	REV. B
APPROVED	<i>PH</i>	SHEET 4 OF 8
DE APPR.	<i>PH</i>	TITLE LATCH ASSEMBLY
DATE	08.06.25	SCALE NTS

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8 7 6 5 4 3 2 1

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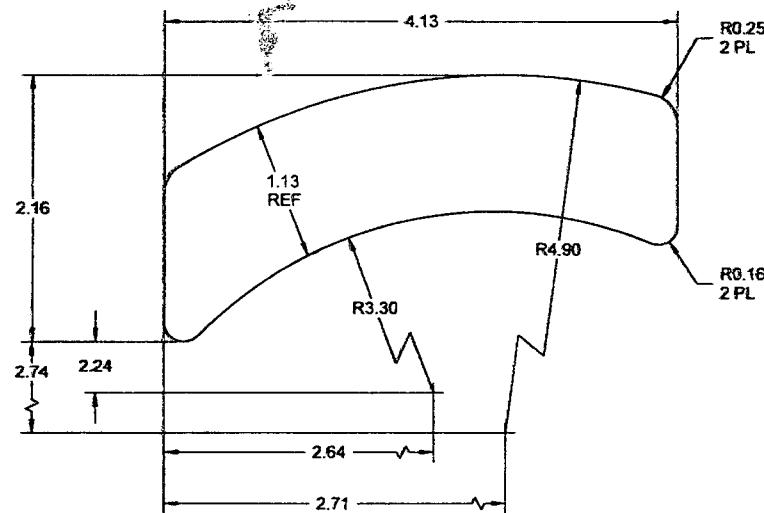
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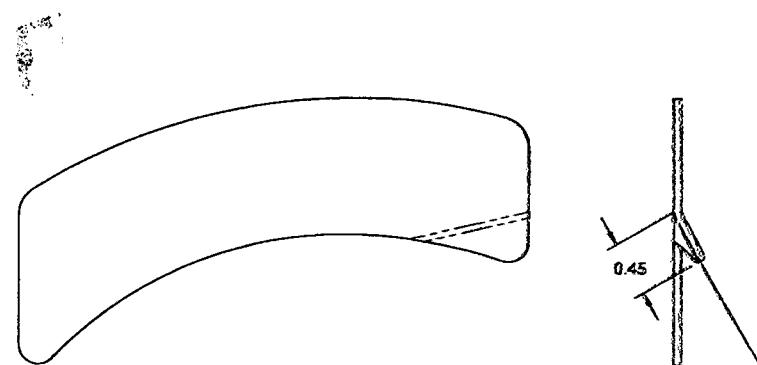
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3589-7F AFT GUIDE PLATE
FLAT PATTERN



D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F

D

C

B

A

RELEASED
Spofford

W10 55102

DESIGN	<i>1</i>	DART AEROSPACE LTD
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>1</i>	DRAWING NO.
MFG. APPR.	<i>1</i>	REV. B
APPROVED	<i>10</i>	D3589
DE APPR.	<i>1</i>	SHEET 5 OF 8
DATE	08.06.25	TITLE
		SCALE
		NTS
		LATCH ASSEMBLY

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D3589-7F NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524,
 OR MIL-S-5059 (ANNEALED) 2B FINISH
 16 GAUGE (0.068 THICK), (REF. DART SPEC M304S16GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.09 lbs

8 7 6 5 4 3 2 1

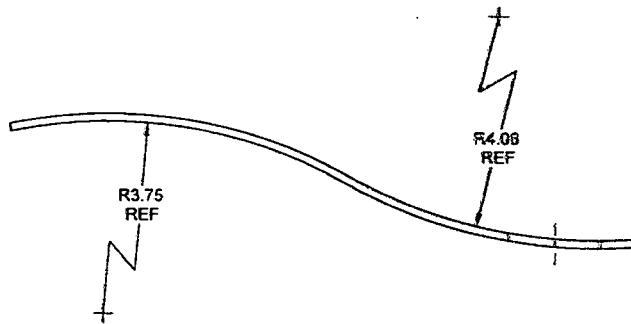
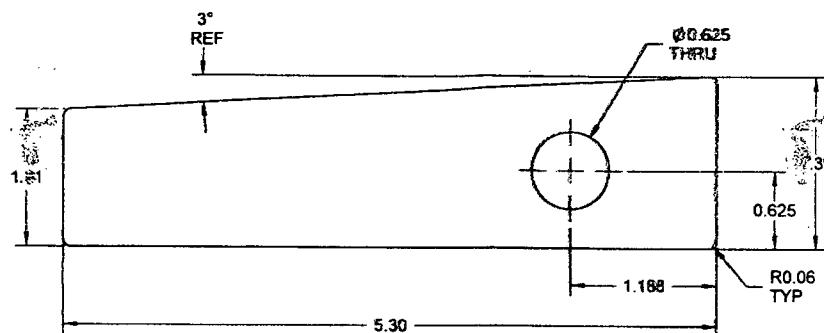
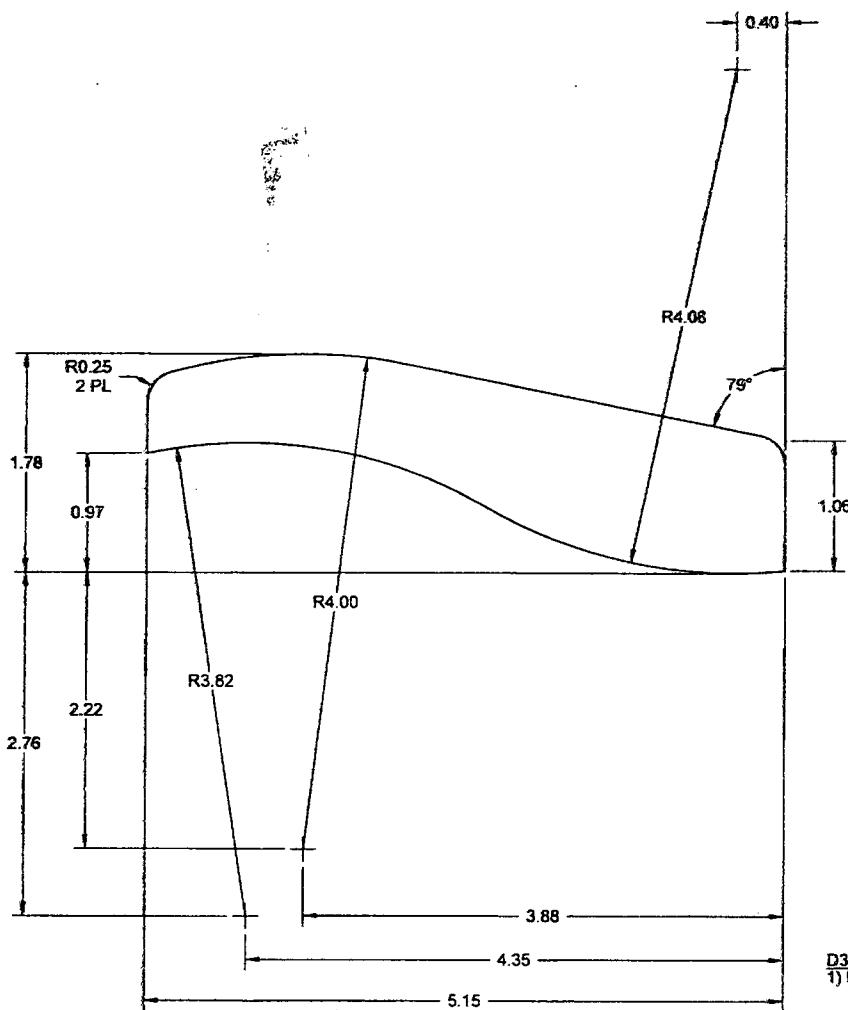
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3589-9-11/11F NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET.
 PER AMS 5513 OR AMS 5524,
 OR MIL-S-5059 (ANNEALED) 2B FINISH
 16 GAUGE (0.063 THICK),
 (REF. DART SPEC M304S16GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS
 OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.09 lbs EACH
 8) CONTROL SHAPE PER DT9021 TEMPLATE

DESIGN	<i>JK</i>	DART AEROSPACE LTD
DRAWN	<i>JK</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>JK</i>	DRAWING NO. D3589
MFG. APPR.	<i>JK</i>	REV. B
APPROVED	<i>JK</i>	SHEET 6 OF 8
DE APPR.	<i>JK</i>	TITLE FORWARD GUIDE PLATE
DATE	08.06.25	SCALE NTS

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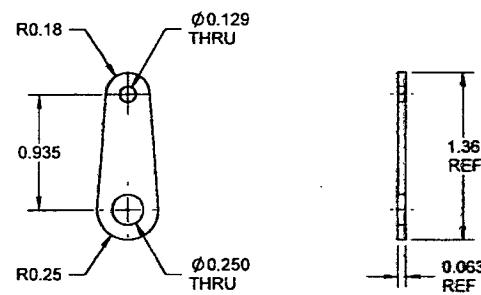
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

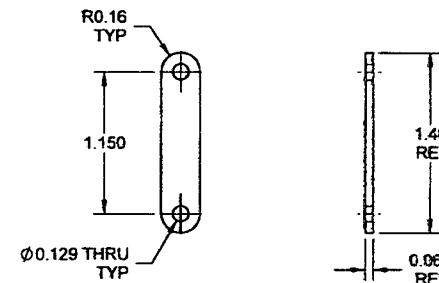
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3589-13 LUG



D3589-15 LINK

RELEASED
09/06/05 MM

W/0 55102

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3589
MFG. APPR.		REV. B
APPROVED		SHEET 7 OF 8
DE APPR.		TITLE LATCH ASSEMBLY
DATE	08.06.25	SCALE NTS

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D3589-13/15 NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524,
 OR MIL-S-5059 (ANNEALED) 2B FINISH
 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.01 lbs EACH

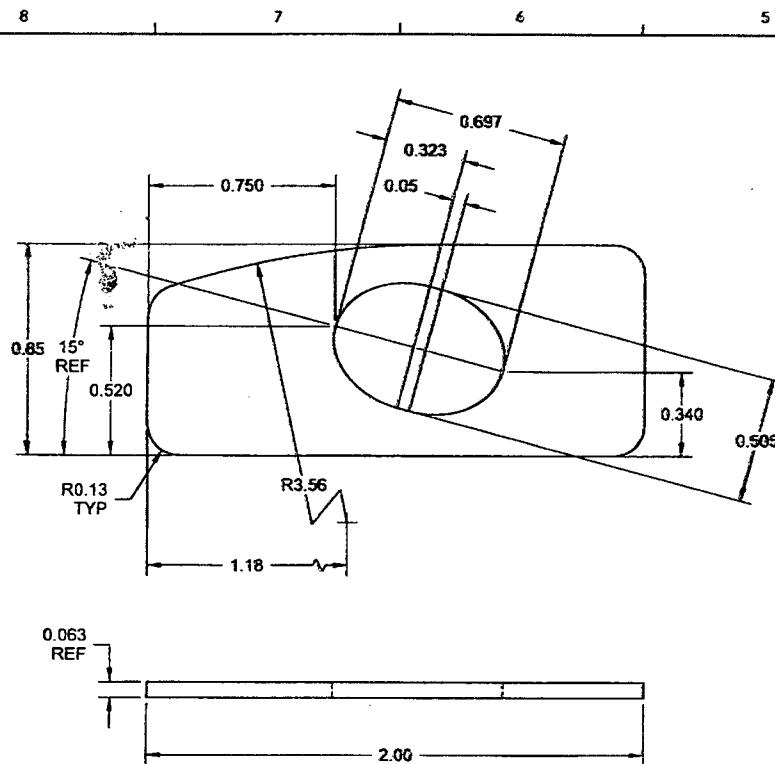
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

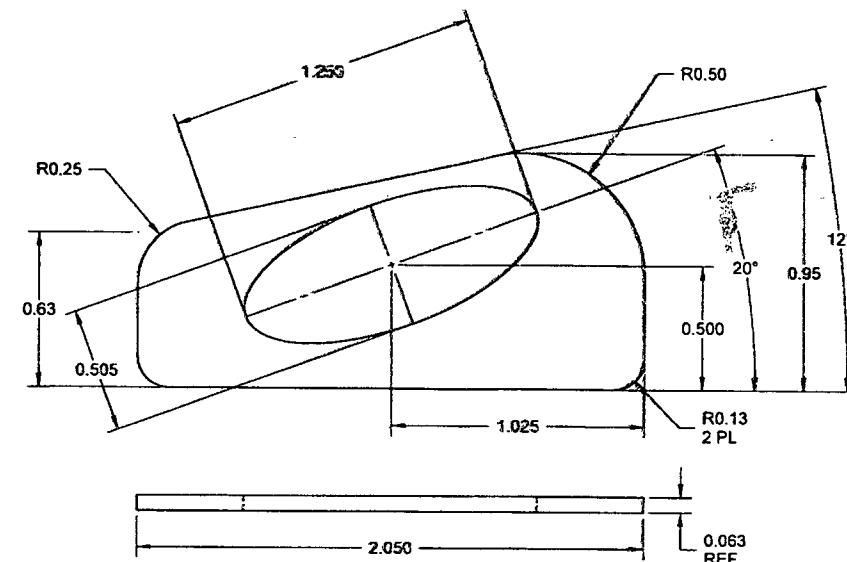
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

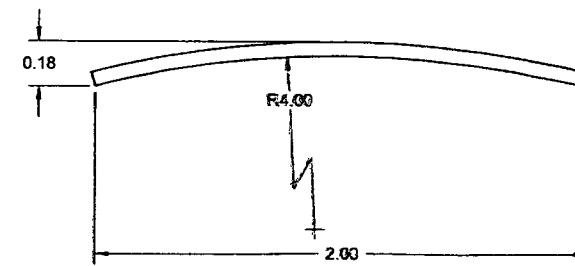
NOTE: Date & initial all entries



D3589-17 FORWARD GUIDE PLATE



D3589-19F AFT GUIDE PLATE FLAT PATTERN



D3589-19 AFT GUIDE PLATE
(WAKE FROM D3589-19F)

RELEASED
09/02/05

W10 55102

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. B
APPROVED	<i>[Signature]</i>	D3589 SHEET 8 OF 8
DE APPR.	<i>[Signature]</i>	TITLE
DATE	08.06.25	SCALE
		NTS

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D3589-17-19-19F NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524,
 OR MIL-S-5059 (ANNEALED) 2B FINISH
 16 GAUGE (0.063 THICK). (REF. DART SPEC M304S16GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.02 lbs EACH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries